

Date: Wednesday, 10/06/2009 2:38:41 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	: 48467			Part Number	: D2596	
Estimate Number	: 10346			Drawing Number	: D2596 REV D	
P.O. Number	:			Project Number	: N/A	
This Issue	: 10/06/2009		S.O. No. :	Drawing Revision	: D	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	SKIDTUBES	Due Date	: 17/06/2009
Previous Run	: 47924				Qty:	6 Um: Each
Written By	:					
Checked & Approved By	: <u>Jul 09.06.10</u>					
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n 'I' Beam Web 4"	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Extrusion "I" Beam Web 4"	
		Pick: Qty Part Number Description Batch	<u>840196 BE 09-06-11</u>
2.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr	<u>3 BE 09-06-11</u>
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1	<u>BE 09-06-11</u>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>10.06.11 6</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

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Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

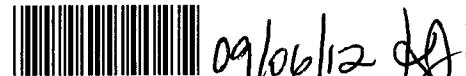
Identify and Stock

Location: LG

BE 09/06/11

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.06.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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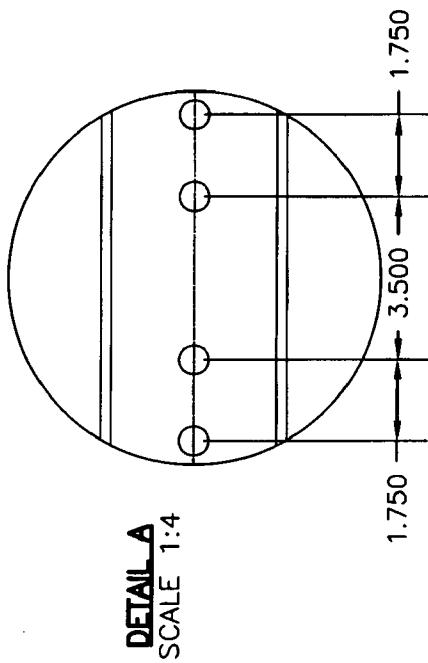
NOTE: Date & initial all entries

DART

DESIGN <i>RH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2596	REV. D	SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20	
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		

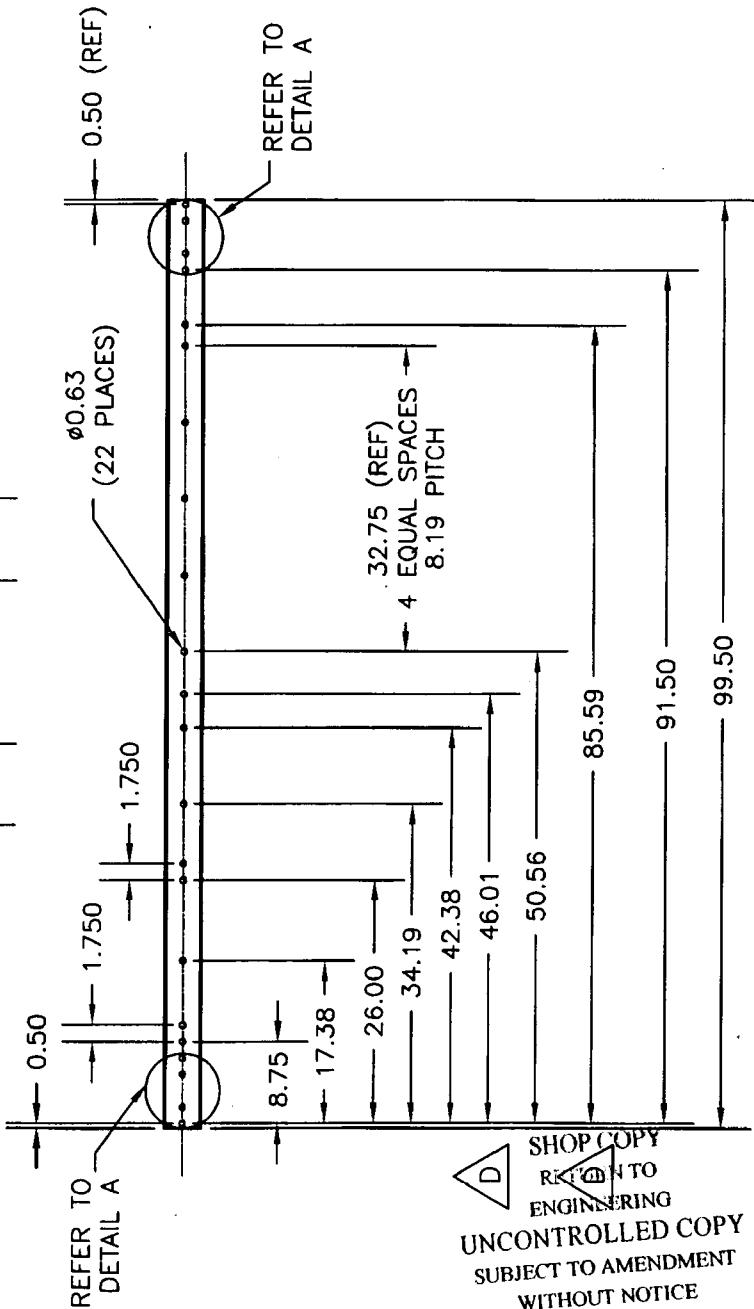
RELEASED
07.06.28 #

07.06.08 -



DETAIL A

SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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